

Work Order ID 84198

84198

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May-07-12 11:22:39 AM

Item ID: D2171

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 07/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/07

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2171

Rev D

(16)

100

0.00

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

B12-5-11

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84198

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84198

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Item ID: D2171 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp
Start Date: 07/05/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 23/05/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(16)			NW 12.05.14
130 *130* Brake NC Brake NC	Form as per dwg Small Fab Memo 1- remove press and machine marking as necessary	0.00 0.00				16			DB 12/05/15
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(16)			8-26-15

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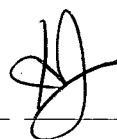
Page 3

May-07-12 11:22:39 AM

Item ID: D2171 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 07/05/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 23/05/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>S 1457</u>	0.00							
150									
Packaging	Memo	0.00				<u>16</u>		<u>545 12/5/15</u>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/5/16 

ME
12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 84198

84198

Parent Item: D2171

D2171

Parent Item Name: Clamp

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	238.3720	0.0258	0.325895	1		
M304S16GA									**			B-12-5-11	
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

238.372

120866

14.246

120877

32.126

121626

192

120866

16

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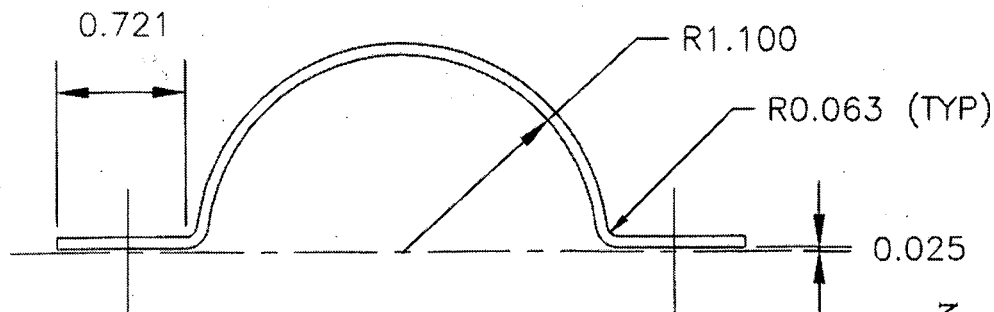
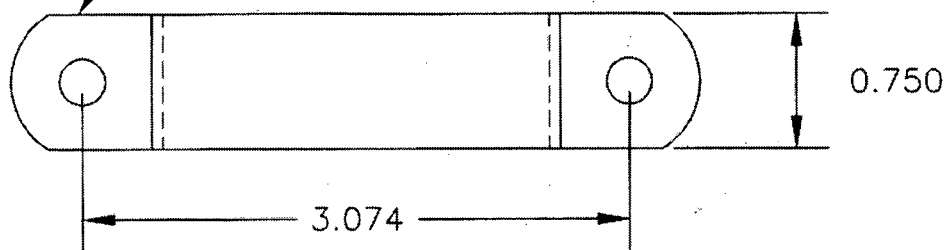
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

RELEASED
99.03.11 KE

PUNCH ENDS PER SPEC
CONTROL DRAWING D2727



MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



12/05/04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84198415

W/O:		WORK ORDER CHANGES					
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